

Work Order ID 72269

Thursday, October 06, 2011 8:28:21 AM

72269

DUPLICATE

Page 1

Item ID: D4271-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Beam Assembly
 Start Date: 7/20/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 8/1/2011 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 11-10-6 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4271	D								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Pick and Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location <u>8196</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

11/10/06 / E/S 11/10/06 (3)

E/S 11/10/06 (3)

(3x) 8P11-10-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

Thursday, October 06, 2011 8:28:21 AM

Item ID: D4271-013

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Beam Assembly

Stop *NS2*

Start Date: 7/20/2011 **Start Qty:** 3.00

3

Cust Item ID:

Required Date: 8/1/2011 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code	Plan Description	Plan Type	Plan Status	Plan Effective Date	Plan Termination Date	Plan Renewal Date	Plan Renewal Period	Plan Renewal Amount	Plan Renewal Frequency	Plan Renewal Method	Plan Renewal Notes
1000	General Insurance	1000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1000	Monthly	Automatic	
2000	Life Insurance	2000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$500	Monthly	Automatic	
3000	Health Insurance	3000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$2000	Monthly	Automatic	
4000	Disability Insurance	4000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1500	Monthly	Automatic	
5000	Property Insurance	5000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$800	Monthly	Automatic	
6000	Liability Insurance	6000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1200	Monthly	Automatic	
7000	Travel Insurance	7000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$300	Monthly	Automatic	
8000	Auto Insurance	8000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$600	Monthly	Automatic	
9000	Home Insurance	9000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$900	Monthly	Automatic	
10000	Life Insurance	10000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1000	Monthly	Automatic	
11000	Health Insurance	11000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$2000	Monthly	Automatic	
12000	Disability Insurance	12000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1500	Monthly	Automatic	
13000	Property Insurance	13000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$800	Monthly	Automatic	
14000	Liability Insurance	14000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1200	Monthly	Automatic	
15000	Travel Insurance	15000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$300	Monthly	Automatic	
16000	Auto Insurance	16000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$600	Monthly	Automatic	
17000	Home Insurance	17000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$900	Monthly	Automatic	
18000	Life Insurance	18000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1000	Monthly	Automatic	
19000	Health Insurance	19000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$2000	Monthly	Automatic	
20000	Disability Insurance	20000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1500	Monthly	Automatic	
21000	Property Insurance	21000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$800	Monthly	Automatic	
22000	Liability Insurance	22000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1200	Monthly	Automatic	
23000	Travel Insurance	23000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$300	Monthly	Automatic	
24000	Auto Insurance	24000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$600	Monthly	Automatic	
25000	Home Insurance	25000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$900	Monthly	Automatic	
26000	Life Insurance	26000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1000	Monthly	Automatic	
27000	Health Insurance	27000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$2000	Monthly	Automatic	
28000	Disability Insurance	28000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1500	Monthly	Automatic	
29000	Property Insurance	29000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$800	Monthly	Automatic	
30000	Liability Insurance	30000	Active	2023-01-01	2023-12-31	2024-01-01	12 Months	\$1200	Monthly	Automatic	
31000	Travel Insurance	31000	Active	2023-01-01	2023-12-31	2024-01-01					

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

11/10/12

MF
11-10-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 06, 2011 8:28:21 AM

Page 1

Work Order ID: 72269

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 7/20/2011

Required Date: 8/1/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC IPP RevB 11.01.26 RevB dwg
EC verified by:DD IPP RevC 11.07.20 per rev PD1 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-027 End Fitting Assembly Aft Beam		Manufactured	No				Each	0.0000					
D4276-1 Aft Beam		Manufactured	No			100	Each	3.0000	1	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST169		3							
				71934		3							
AN3C12A Bolts		Purchased	No			100	Each	100.0000	6	18			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		100							
				117514		4							
				118112		5							
				118422		17							
				118451		24							
				118838		50							
MS21043-3 Nut		Purchased	No			100	Each	955.0000	6	18			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		72							
				103691		72							
				ST301		883							
				118077		1							
				118614		492							
				118686		390							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 06, 2011 8:28:21 AM

Page 2

Work Order ID: 72269

Parent Item: D4271-013

Parent Item Name: Aft Beam Assembly

Start Date: 7/20/2011

Required Date: 8/1/2011

Start Qty: 3.00

Required Qty: 3.00

NAS1149C0332R

Purchased

No

100

Each

3,850.0000

12

11/1/11

36

30

Washer

Location

Loc Qty

Loc Code

FP-B

7

117291

7

ST297

3843

116304

55

117460

18

117887

169

118078

2

118179

78

118354

2521

119124

1000

36

Thursday, October 06, 2011 8:28:21 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

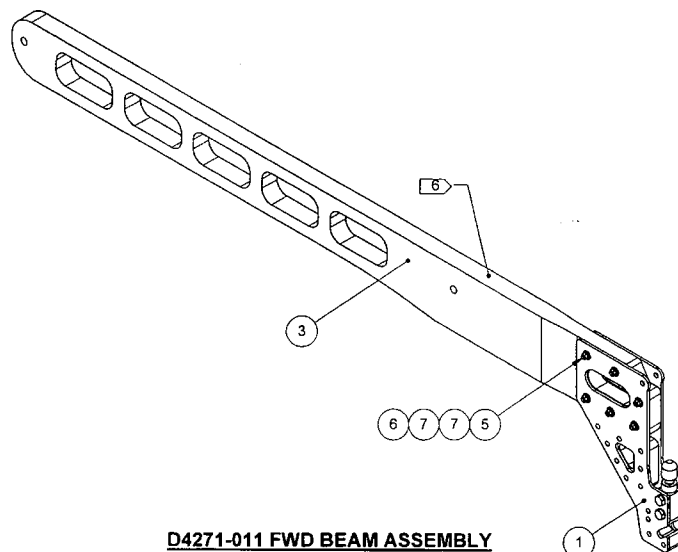
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

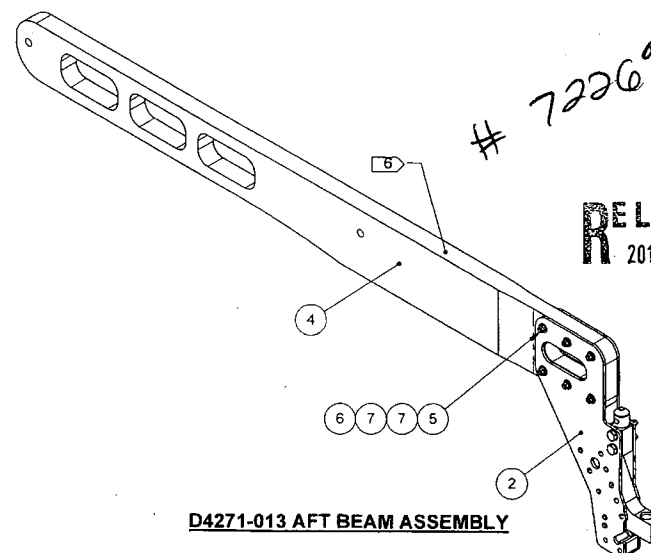
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	97	DRAWING NO.	REV. D
MFG. APPR.	E	D4271	SHEET 1 OF 3
APPROVED	14	TITLE	SCALE
DE APPR.	#	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

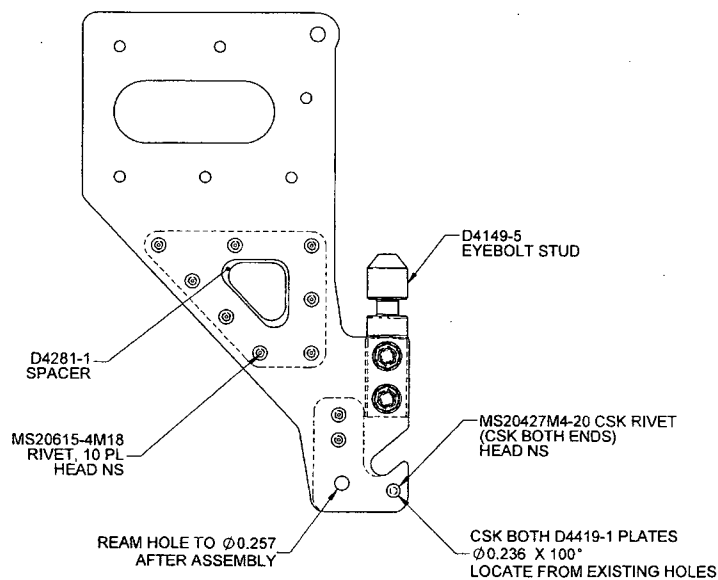
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

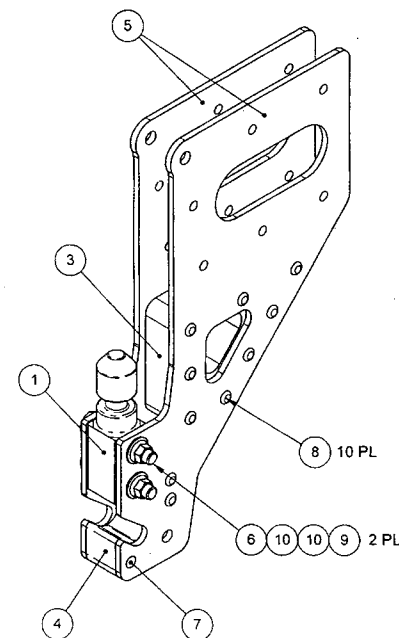
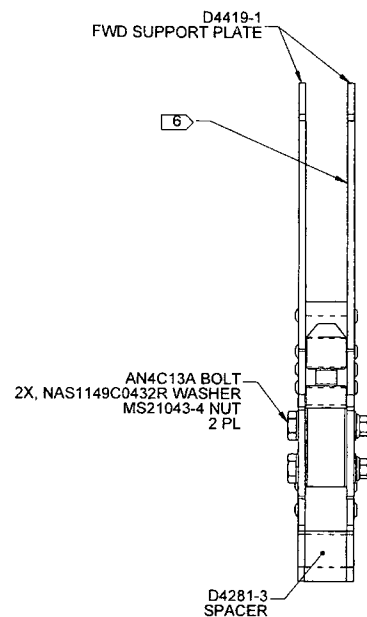
ITEM	QTY -025	P/N	DESCRIPTION
	X	D4271-025	FWD BEAM END FITTING ASSEMBLY
1	1	D4149-5	EYEBOLT STUD
3	1	D4281-1	SPACER
4	1	D4281-3	SPACER
5	2	D4419-1	FWD SUPPORT PLATE
6	2	AN4C13A	BOLT
7	1	MS20427M4-20	CSK RIVET (MONEL)
8	10	MS20615-4M18	RIVET (MONEL)
9	2	MS21043-4	NUT
10	4	NAS1149C0432R	WASHER



D4271-025 FWD BEAM END FITTING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-025" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 2.69 lbs



RELEASED
2011-07-28

#72267

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D4271	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

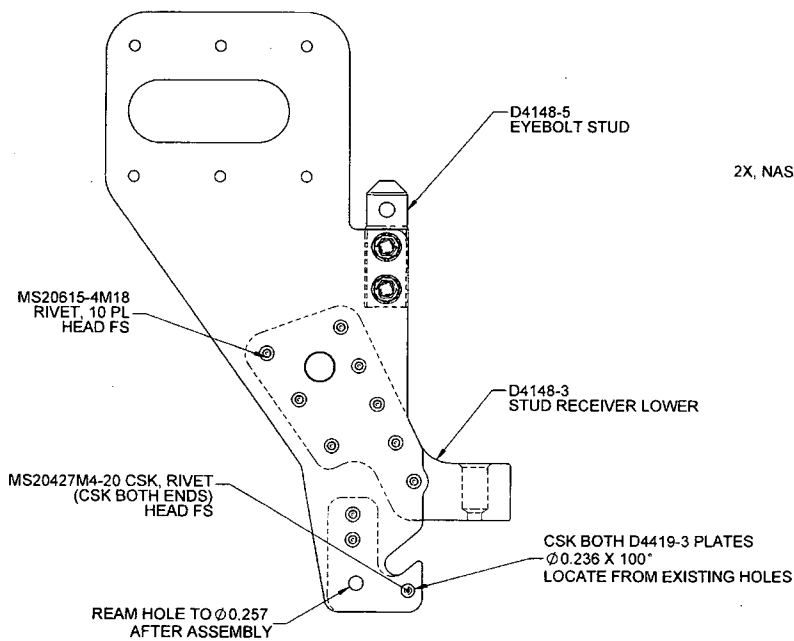
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

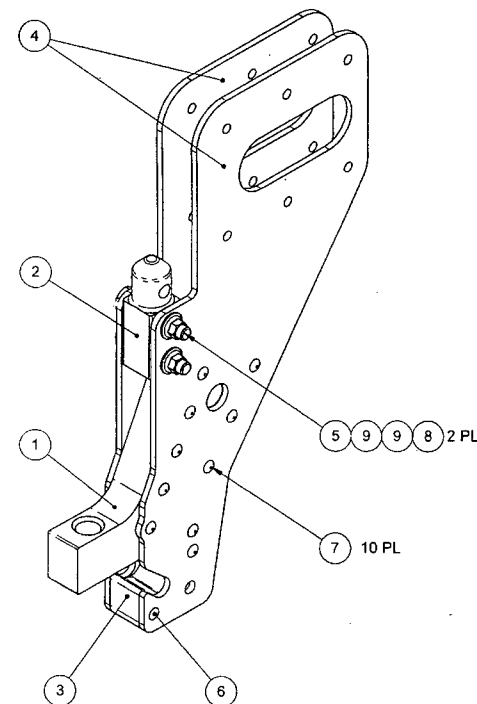
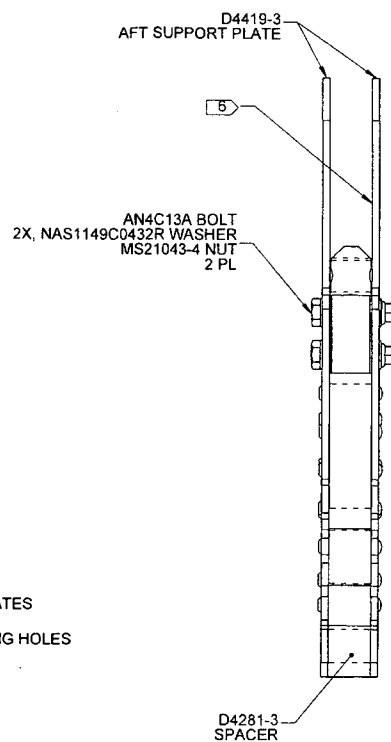
ITEM	QTY -027	P/N	DESCRIPTION
	X	D4271-027	AFT BEAM END FITTING ASSEMBLY
1	1	D4148-3	STUD RECEIVER LOWER
2	1	D4148-5	EYEBOLT STUD
3	1	D4281-3	SPACER
4	2	D4419-3	AFT SUPPORT PLATE
5	2	AN4C13A	BOLT
6	1	MS20427M4-20	CSK RIVET (MONEL)
7	10	MS20615-4M18	RIVET (MONEL)
8	2	MS21043-4	NUT
9	4	NAS1149C0432R	WASHER



D4271-027 AFT BEAM END FITTING ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-027" AND B/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 4.25 lbs



DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>QJ</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>E</i>	D4271	SHEET 3 OF 3
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	SUPPORT BEAM ASSEMBLIES	NTS
DATE	11.07.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2011-07-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries